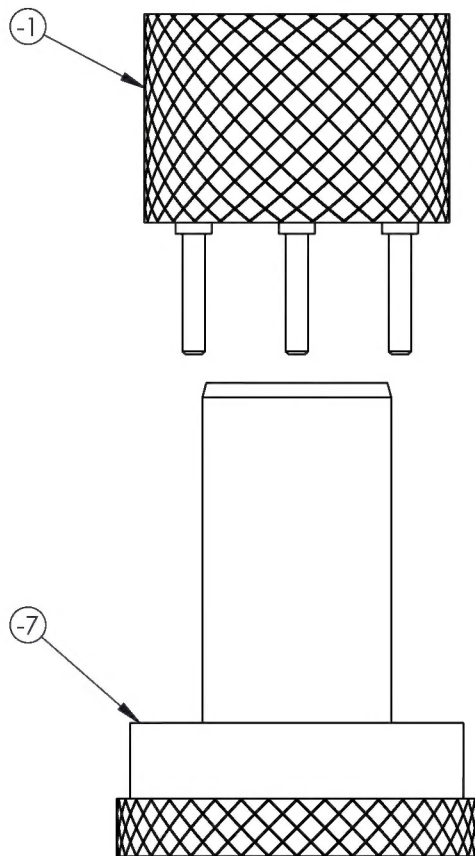



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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D DIM. PRECISION FROM .XXX TO .XX ON NON-CRITICAL PARTS. REMOVED 1/N'S FROM BOM. UPDATED TITLE BLOCKS - 3 ADDED .03 X 45° CHAMFER TO PRESS FIT PIN. - 7 CH'D TO 1 PEICE WAS ASSY. DELETED - 9 & - 11 .	10/17/2013	CFS	RW
2	- 3 CH'D DIM WAS 1.260 IS 1.254, WAS .115 IS .118. ADDED CHAMFER WAS .03 X 45° IS 2X .03 X 45°. - 5 CH'D BOLT CIRCLE WAS Ø2.382 IS 2.479, ADDED .12 X 15° CHAMFER, ADDED R.031 MAX, ADDED ENGRAVE "RBW109-3130-70-111". - 7 CH'D CHAMFER WAS .15 X 30° IS .15 X 15°, CH'D DIM'S WAS 3.93 IS 4.93, WAS 2.925 IS 3.93, WAS 2.515 IS 3.54, WAS Ø2.95 IS 2.954. ADDED 2X R.015 MAX.	4/17/2014		

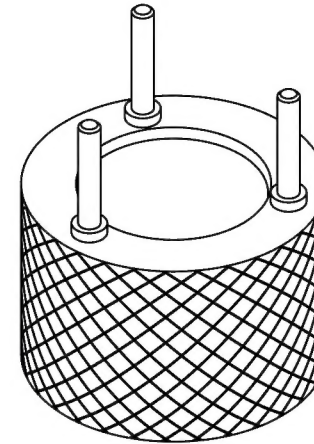
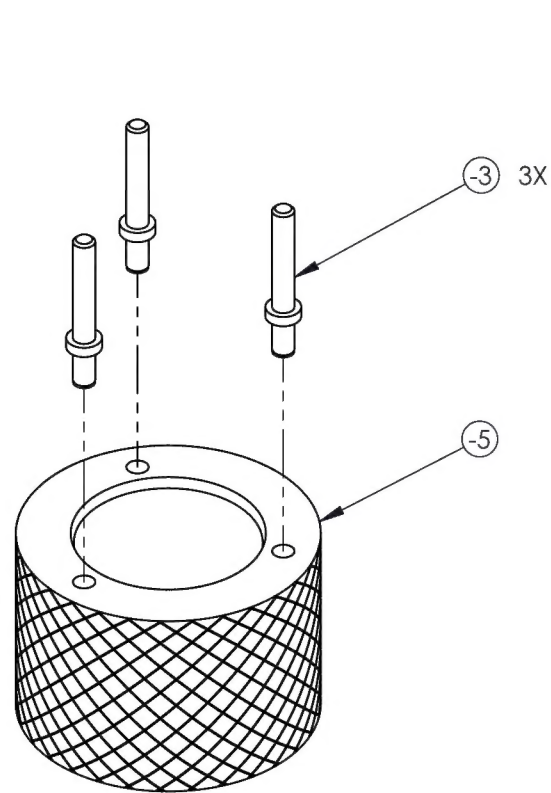


ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	BARREL ASSY			2
	3		-3		PIN	4140 Q & T	Ø3/8 X 2	3
	1		-5		BARREL	6061	Ø3-1/4 X 2-1/4	4
			-7	1	BASE	6061	Ø3-3/4 X 5-1/8	5
	ASSY -1							

 RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO. RBW109-3130-70-101	REV 2
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW109
SCALE 1:2	DATE 4/5/2011
SHEET 1 OF 5	


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED



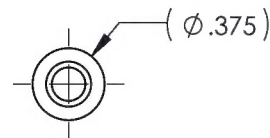
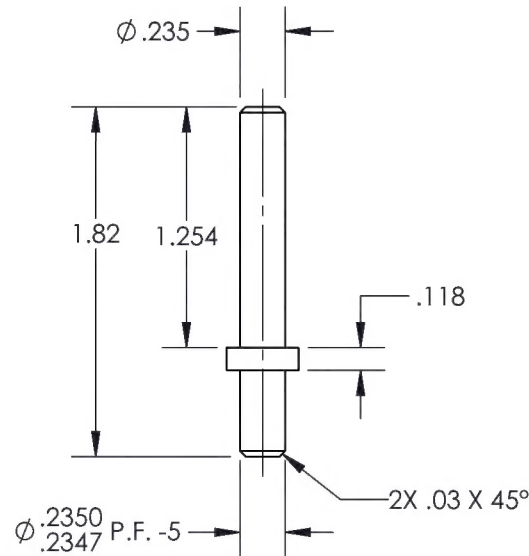
NOTE:
1. PRESS 3 PINS INTO BARREL

-1
BARREL ASSY

 RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO. RBW109-3130-70-101-1	REV 2
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109
SCALE 1:2	DATE 3/30/2011
SHEET 2 OF 5	


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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-3 ADDED .03 X 45° CHAMFER TO PRESS FIT PIN.	10/17/2013	CFS	RW
2	-3 CH'D DIM WAS 1.260 IS 1.254, WAS .115 IS .118, ADDED CHAMFER WAS .03 X 45° IS 2X .03 X 45°.	4/17/2014	RJC	DW



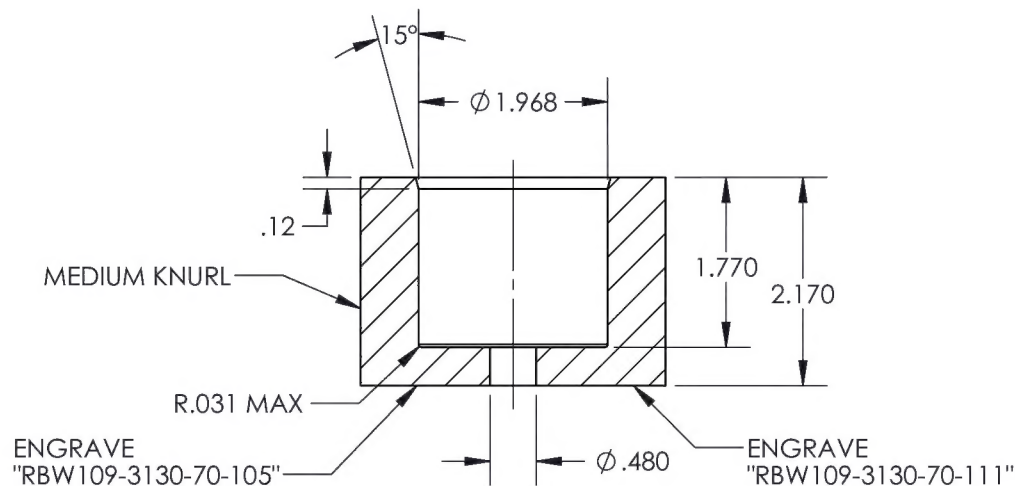
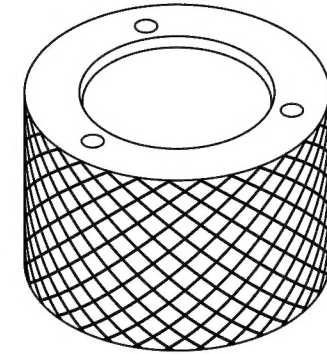
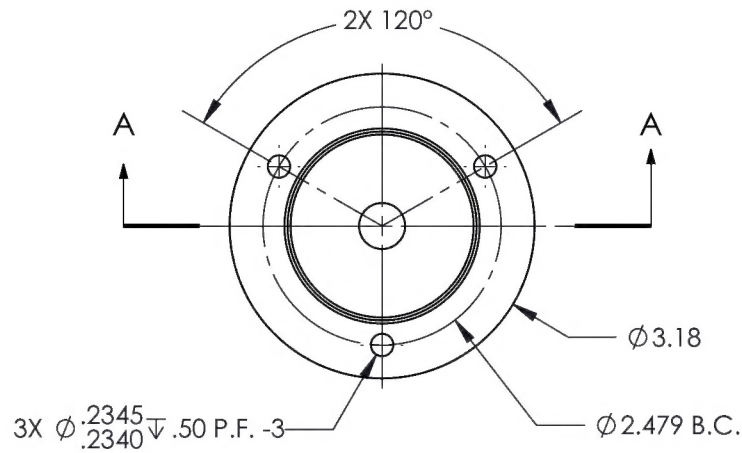
(-3)

PIN

 RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO. RBW109-3130-70-101-3	REV 2
MAT'L 4140 Q & T	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CAD PLATE YELLOW
.X ± .1	SPEC QQ-P-416F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109
SCALE 1:1	DATE 3/30/2011
SHEET 3 OF 5	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-5 CH'D BOLT CIRCLE WAS Ø2.382 IS 2.479, ADDED .12 X 15° CHAMFER, ADDED R.031 MAX, ADDED ENGRAVE "RBW109-3130-70-111".	4/17/2014	RJC	DW



SECTION A-A

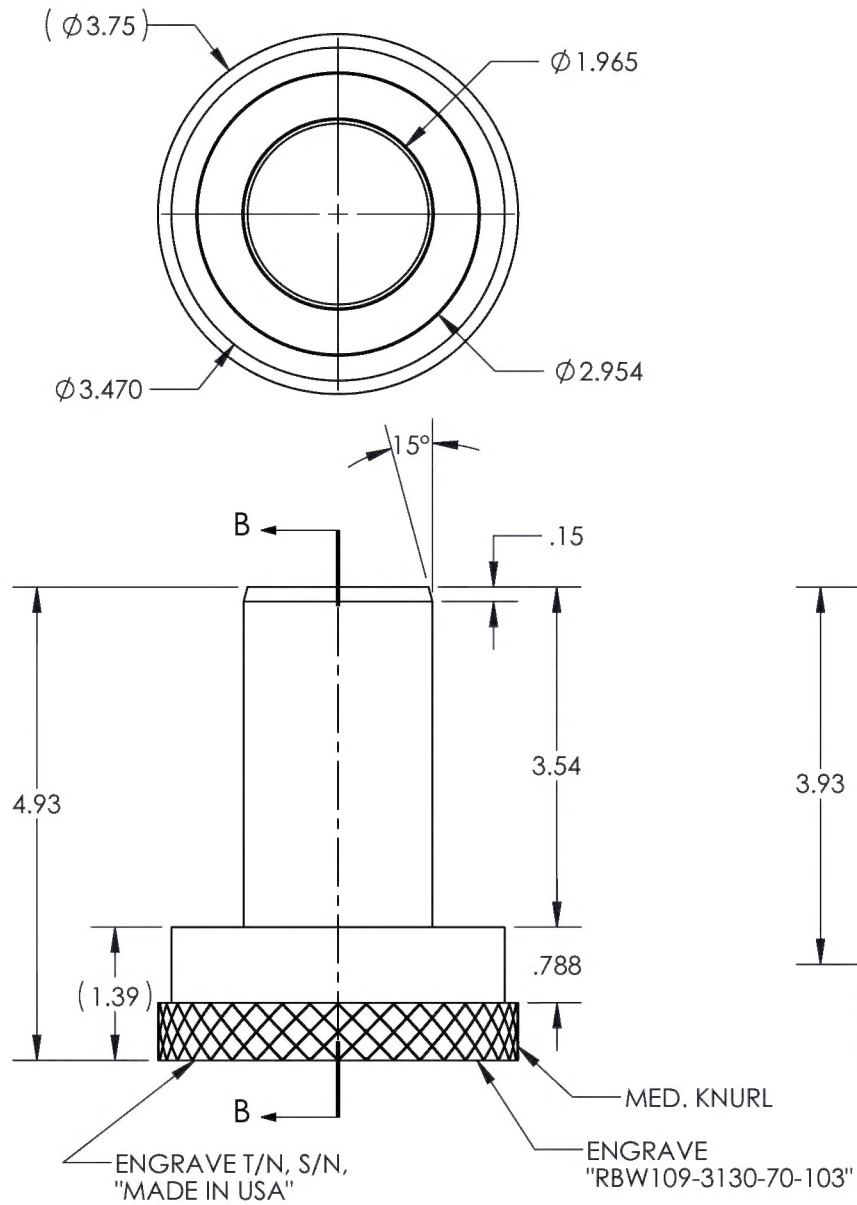
(-5)

BARREL

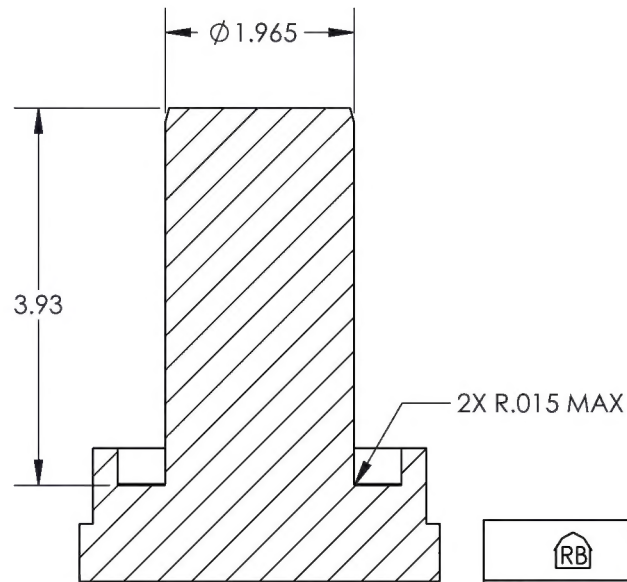
 RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO. RBW109-3130-70-101-5	REV 2
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	APPROVED <i>D Weil</i> HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL AW109
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 4/4/2011
SHEET 4 OF 5	

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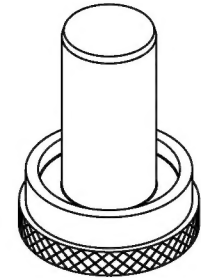
REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-7 CH'D CHAMFER WAS .15 X 30° IS .15 X 15°, CH'D DIM'S WAS 3.93 IS 4.93, WAS 2.925 IS 3.93, WAS 2.515 IS 3.54, WAS Ø2.95 IS 2.954. ADDED 2X R.015 MAX.	4/17/2014	RJC	DW



(-7)
BASE



SECTION B-B



RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING DUPLEX BEARING REMOVAL	
DWG NO. RBW109-3130-70-101-7	REV 2
MAT'L 6061	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH CLEAR ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS I
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AW109
SCALE 1:2	DATE 3/25/2011
SHEET 5 OF 5	